

SNIB DEC 23rd

Work Order ID 153259

Tuesday, November 15, 2016 11:17:43 AM

153259

PRELIMINARY ISSUE

Page 1

Item ID: 647.7341

Accept

N900040100

Setup Start

NS1

Revision ID:

POSITIVE
RECALL

Stop

NS2

Item Name: Wiper Deflector Assembly

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

VS

(Signature)

Date: 16/11/15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7341								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DEC 15 2016

DAS
6
9-89

DAS
21
9-89

16-12-10

DAS
27
9-89

DEC 20 2016

DEC 15 2016

DAS
6
9-89

MF
16-12-21

DAS
27
9-89

DEC 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 153259***153259***

Page 2

Tuesday, November 15, 2016 11:17:43 AM

Item ID: 647.7341 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wiper Deflector Assembly
Start Date: 12/15/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				DAS 27 9-89			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 647.7341 Location : FG109 <i>Sold</i>								
140	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
140									
QC	Memo	0.00							
Quality Control									

DEC 20 2016

DEC 21 2016

MF 16-12-21
POSITIVE RECALL
EFFECTIVE 16-11-18 AUTH *[Signature]*
RELEASED DATE *[Signature]*
RD16-1006-01

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, November 15, 2016 11:17:42 AM

Page 1

Work Order ID: 153259

153259

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.09.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1601 *647 1601* Wiper Deflector Aft DAS 27 9-89		Manufactured	No				Each	3.0000	**	1 DEC 21 2016			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK091			3						
					148295		1			153312			
					151482		2						
647.1610 *647 1610* Wiper Deflector Fwd DAS 27 9-89		Manufactured	No				Each	17.0000	**	1 DEC 15 2016			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK091			17						
					125082		13						
					M130388		4						
647.1914 *647 1914* Bracket DAS 27 9-89		Manufactured	No				Each	5.0000	**	1 DEC 15 2016			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK110			5						
					109733		5						
647.1602 *647 1602* Doubler Assembly DAS 27 9-89		Manufactured	No				Each	24.0000	**	1 DEC 15 2016			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK107			24						
					92479		3						
					M130388		21						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Picklist Print

Tuesday, November 15, 2016 11:17:42 AM

Page 2

Work Order ID: 153259

153259

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

647.3201 Manufactured No

Each 4.0000

1

647 3201

Grounding Cable Assembly

**

1533/5

DEC 15 2016

DAS 6 9-89

Location

Loc Qty

Loc Code

cck111

4

123417

4

AN4CH6A

Purchased

No

Each

40.0000

1

AN4CH6A

Bolt

**

DEC 15 2016

DAS 6 9-89

Location

Loc Qty

Loc Code

ST345

40

123525

20

m126176

20

MS21042-08

MS21042L08

Purchased

No

Each

0.0000

1

MS21042-08

USE MS21042L08

**

13699

DEC 15 2016

DAS 6 9-89

MS21042-3

MS21042L3

Purchased

No

Each

0.0000

3

MS21042-3

Nut

**

13595

DEC 15 2016

DAS 6 9-89

MS27039-08-07

Purchased

No

Each

100.0000

1

MS27039-08-07

SCREW

**

DEC 15 2016

DAS 6 9-89

Location

Loc Qty

Loc Code

ST278

100

m132035

100

DAS 27 9-89

Tuesday, November 15, 2016 11:17:43 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, November 15, 2016 11:17:43 AM

Page 3

Work Order ID: 153259

153259

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-07

Purchased

No

Each

182.0000

3

MS27039-1-07

Screw

DEC 15 2016

Location

Loc Qty

Loc Code

GA

2

125654

2

ST281

180

m135948

180

Each

706.0000

4

MS27039-1-14

Purchased

No

MS27039-1-14

Screw

DEC 15 2016

Location

Loc Qty

Loc Code

GA

94

120449

94

over006

500

124326

500

ST280

112

124326

112

Each

60.0000

3

601.2999

Manufactured

No

601 2999

Screw

DEC 15 2016

Location

Loc Qty

Loc Code

CCK098

60

91707

10

93369

50

DAS
27
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

Tuesday, November 15, 2016 11:17:43 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

Picklist Print

Tuesday, November 15, 2016 11:17:43 AM

Work Order ID: 153259

153259

Parent Item: 647.7341

647 7341

Parent Item Name: Wiper Deflector Assembly

Start Date: 12/15/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

1,463.000

2

NAS1149FN832P

Washer

**

DEC 15 2016

DAS
6
9-89DAS
27
9-89LocationLoc QtyLoc Code

GA

1285

M135058

1285

ST263

178

M135603

178

2

mf

NAS1149F0332P

Purchased

No

Each

2,610.000

10

NAS1149F0332P

Washer

**

DEC 15 2016

DAS
6
9-89DAS
27
9-89LocationLoc QtyLoc Code

GA

343

m133709

343

ST262

2267

m135544

267

m135948

2000

10

mf

601.2375

Manufactured

No

Each

62.0000

3

601 2375

Washer

**

DEC 15 2016

DAS
6
9-89DAS
27
9-89LocationLoc QtyLoc Code

CCK096

62

91708

62

3

mf

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 15: Universal Wiper Deflector (WD) Assembly, 647.7341

FIND #	PART #	DESCRIPTION	QTY
4	647.1601	WIPER DEFLECTOR ASSY, AFT	1
5	647.1610	WIPER DEFLECTOR, FWD	1
29	647.1914	BRACKET	1
30	647.1602	DOUBLER ASSY	1
35	647.3201	GROUNDING CABLE ASSY	1
47	601.1324	BOLT	1
52	601.2973	LOCKNUT	1
53	601.2943	LOCKNUT	3
60	601.2525	SCREW	1
63	601.2198	SCREW	3
67	601.1622	SCREW	4
72	601.2999	SCREW	3
85	601.2764	WASHER	2
86	601.1607	WASHER	10
89	601.2375	WASHER	3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
W/OUT NOTICE
NO. 153289

DEC 15 2016

REFERENCE ONLY



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 15: Universal Wiper Deflector (WD) Assembly, 647.7341

FIND #	PART #	DESCRIPTION	QTY
4	647.1601	WIPER DEFLECTOR ASSY, AFT	1
5	647.1610	WIPER DEFLECTOR, FWD	1
29	647.1914	BRACKET	1
30	647.1602	DOUBLER ASSY	1
35	647.3201	GROUNDING CABLE ASSY	1
47	601.1324	BOLT <i>AN4CHK6A</i>	1
52	601.2973	LOCKNUT <i>MS21042-08</i>	1
53	601.2943	LOCKNUT <i>MS21042-3</i>	3
60	601.2525	SCREW <i>MS27039-0807</i>	1
63	601.2198	SCREW <i>MS27039-1-07</i>	3
67	601.1622	SCREW <i>MS27039-1-14</i>	4
72	601.2999	SCREW <i>NAS1149FN832P</i>	3
85	601.2764	WASHER <i>NAS1149FN832P</i>	2
86	601.1607	WASHER <i>NAS1149F032P</i>	10
89	601.2375	WASHER	3

Work Order ID 153259***153259***

Page 1

Friday, December 16, 2016 10:23:59 AM

Item ID: 647.7341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC135 Universal Wiper Deflector Assembly

Start Date: 12/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

MPP-195

N/C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 647.7341

DAS
21
9-89

DEC 16 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

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From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

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From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM